

Work Order ID 48168

June 26, 2009 7:31:24 AM



Page 1

Item ID: D3684-047
Revision ID: C
Item Name: FWD LEG ASS'Y

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 4.00
Required Date: 03/08/2009 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev C

100 Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 09/08/31

4

8

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 12-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684i ***Ensure holes for AN3C Bolts are free of

Sealant

Nov 08/31

SB 09/08/31

4

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

27 8 09/08/31

4

4

W/O: 48168		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/08/19	110	add #5 NAB 509 - 12c	SB	09/08/19	4	<i>[Signature]</i> 09-08-19	<i>[Signature]</i> 09-08-19

Part No: D3684-047 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 48168

June 26, 2009 7:31:24 AM



Page 2

Item ID: D3684-047
Revision ID: C
Item Name: FWD LEG ASS'Y

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 4.00



Required Date: 03/08/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

09/09/01

4

0

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/02
MF 09-09-01

Picklist Print

June 26, 2009 7:31:23 AM

Page 1

Work Order ID: 48168

Parent Item: D3684-047RevC

Parent Item Name: FWD LEG ASS'Y









Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	0.0000	8.0000			
Bolts												
D3688-1RevB 		Manufactured	No			110	Each	0.0000	4.0000			
*STUD D3689-1RevB 		Manufactured	No			110	Each	0.0000	4.0000			
*SLEEVE D3691-1RevU/R 		Manufactured	No			110	Each	0.0000	4.0000			
*STUD D3692-1RevB 		Manufactured	No			110	Each	0.0000	16.0000			
*SPACER D3693-1RevU/R 		Manufactured	No			110	Each	0.0000	4.0000			
Rod End Bearing MS21043-3 		Purchased	No			110	Each	0.0000	8.0000			
Nut NAS509L12C 		Purchased	No			110	Each	0.0000	4.0000			
Nuts												

M110584 H 112314 SB 09/08/31

B 45670 (2) B 50932 (2)
SB 09/08/31

B 50388 SB 09/08/31

B 50721 (1) B 50722 (2)
SB 09/08/31

B 50736 L6 SB 09/08/31

B 50733 6/09-08-05

B 50734 1

M111819 H 112243 SB 09/08/31

M110844 SB 09/08/31

PTO ~~last page~~

*Date: Friday, 22/05/2009 4:46:19 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD LEG ASS'Y
Job Number : 48168	
Estimate Number : 13175	
P.O. Number :	Part Number : D3684047
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D3684 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 45600	Material :
Written By :	Due Date : 29/05/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.05.25</u>	
Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC Est Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0	✓ D36881	STUD
-----	----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

STUD

batch B 45670 (2x) B 50932 (2) SB 09/08/31

3.0	✓ D36891	SLEEVE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SLEEVE

batch B 50363 SB 09/08/31

4.0	✓ D36911	STUD
-----	----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

STUD

batch B 50721 (1) B 50722 (3) SB 09/08/31

5.0	✓ D36921	SPACER
-----	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

SPACER

batch B 50734 SB 09/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:46:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LEG ASS'Y

Job Number: 48168

Part Number: D3684047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

✓

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rod End Bearing

batch

B 50733 (2)

B 50734 (1)

SS 09/08/31

7.0

✓

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolts

batch

M 110584 (2)

M 112314 (2)

SS 09/08/31

8.0

✓

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch

M 111019 (6)

M 112243 (2)

SS 09/08/31

9.0

✓

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nuts

batch

M 110844

SS 09/08/31

10.0

✓

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nuts

batch

M 112453

SS 09/08/31

11.0

✓

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

SS 09/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:46:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LEG ASS'Y

Job Number: 48168

Part Number: D3684047

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify wiith Dart part # using a fine point permanent marker and Stock

Location: _____

14.0

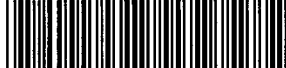
✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D

B

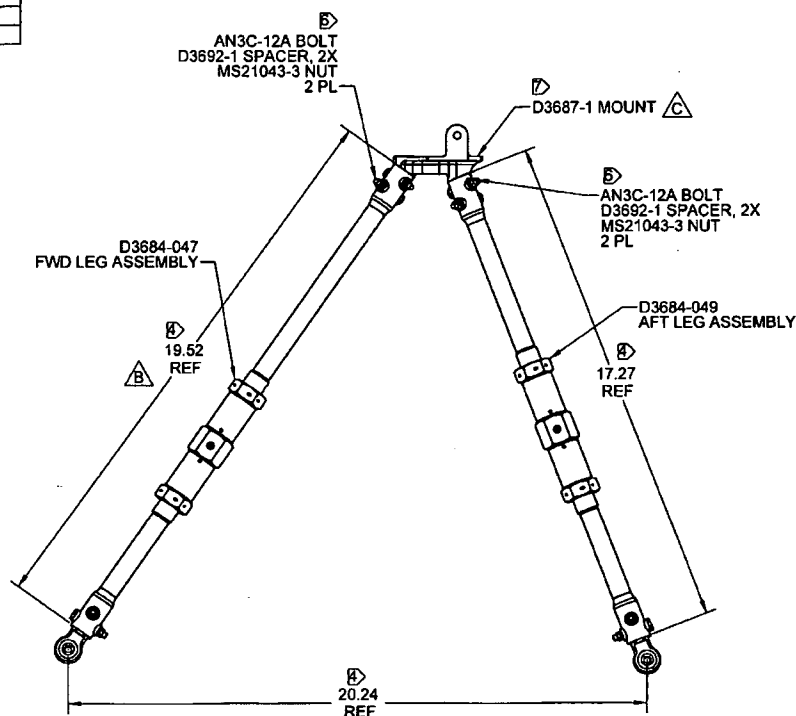
8

A

A

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BIB

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

NOTES:

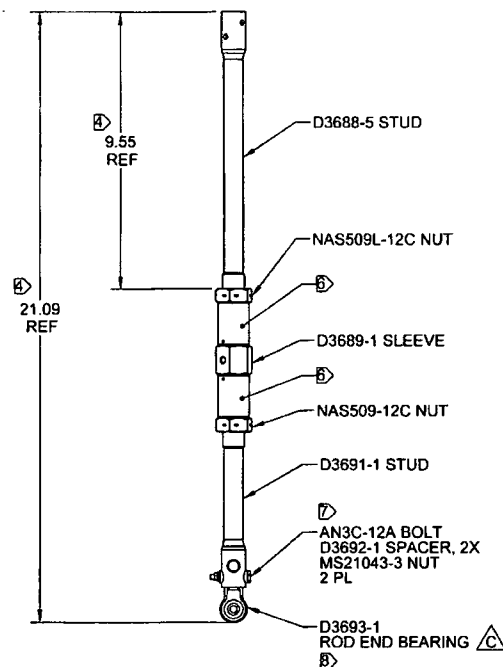
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. C
MFG. APPR.	91	D3684	SHEET 2 OF 5
APPROVED	92	TITLE	SCALE
DE APPR.	93	TRIPOD MOUNT ASSY	NTS
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09/07/12

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4/8/08

ITEM	QTY .045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT







D3684-045 INBOARD LEG ASSEMBLY



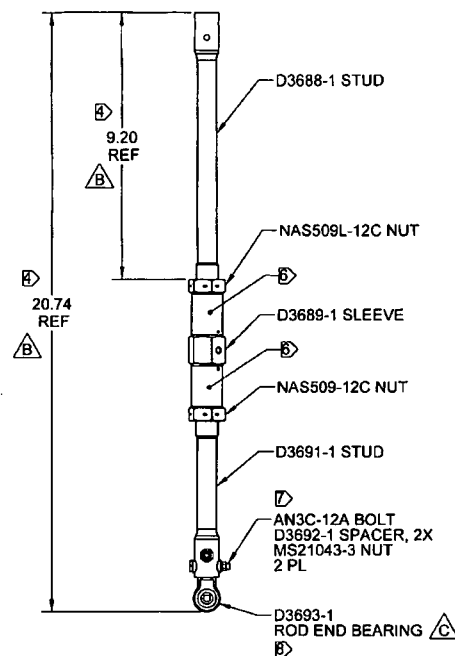
NO. 168102
 WORK FOR
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- NOTES:
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 2) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
 - 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
 - 5) WEIGHT: 3.1 lbs
 - 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
 - 7) TORQUE FASTENERS TO 20-25 in-lbs
 - 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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RELEASED
 09/01/2015

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

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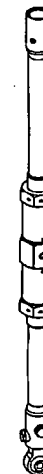
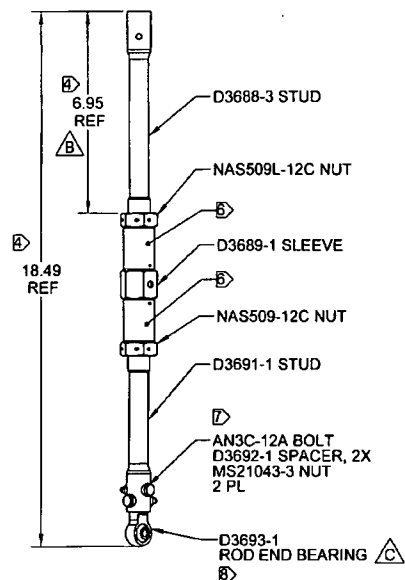
NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
 09/01/12

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT





D3684-049 AFT LEG ASSEMBLY

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NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/12 MP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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